

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:46:04 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 28445
 Estimate Number : 10531
 P.O. Number : N/A Part Number : D2572
 This Issue : 9/6/2006 S.O. No. : N/A Drawing Number : D2572 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 27993 Material : N/A
 Due Date : 9/13/2006 Qty: 6 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B25350

7075-T7351 8.25X5.0X2.5

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No: 28445 Double check by: En 06/09/18

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

5.6/7075 06/09/18

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

5.6/7075 06/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PL Date: 06/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:46:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 28445

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf/5.6

06/09/20

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/09/22 x 6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Lam

06/09/27 x 6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) as per QSI 005 4.3

yl

06/09/28 x 6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9/10/06

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPP K10003*

06/10/06 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/06

Job Completion



06-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28445
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.500	3.499	3.498	3.500		
D	1.745	1.755		1.750	1.749	1.749	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.000		
F	0.490	0.510		0.501	0.495	0.495	0.502		
G	0.257	0.262	DT8683		✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.499	0.499	0.499	0.496		
J	1.174	1.184		1.179	1.179	1.180	1.179		
K	0.558	0.578		0.568	0.569	0.567	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.496	1.496	1.497	1.495		
N	2.495	2.505		2.500	2.499	2.498	2.500		
O	3.869	3.879		3.872	3.870	3.871	3.872		
P	0.115	0.135		0.129	0.124	0.123	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.250	0.250	0.252		
S	0.115	0.135		0.116	0.121	0.121	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.961	2.960	2.966		
V	0.230	0.250		0.238	0.237	0.237	0.238		
W	0.115	0.135		0.118	0.118	0.119	0.123		
X	0.307	0.312		0.309	0.309	0.310	0.309		
Y	0.760	0.765		0.760	0.761	0.761	0.760		
Z	0.352	0.372		0.365	0.364	0.364	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.629	0.628	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.244	0.244	0.245		
AE	1.375	1.395		1.390	1.384	1.383	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.246	0.245	0.247	0.245		
AH	0.240	0.260		0.249	0.248	0.248	0.248		
AI	2.000	2.020	DT8889	2.000	✓	✓	✓		
AJ	0.023	0.043		0.035	0.033	0.033	0.035		
Accept/Reject									

Measured by: J.G./gmc
Date: 06/09/20

Audited by: En
Date: 06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28445
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G	0.257	0.262	DT8683		✓				
H	0.375	0.380	DT8684	✓	✓				
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K	0.558	0.578		0.566	0.566				
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W	0.115	0.135		0.123	0.120				
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AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.622	0.623				
AC	0.053	0.073		0.063	0.067				
AD	0.240	0.260		0.245	0.245				
AE	1.375	1.395		1.384	1.387				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.245	0.245				
AH	0.240	0.260		0.249	0.251				
AI	2.000	2.020	DT8889	✓	✓				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									

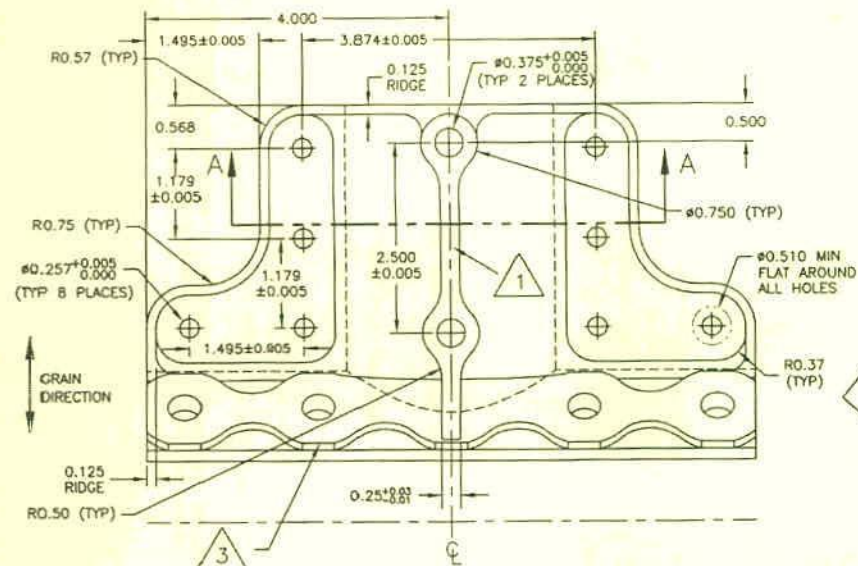
Measured by: <i>me</i>
Date: 06/09/21

Audited by: <i>E</i>
Date: 06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

RELEASED

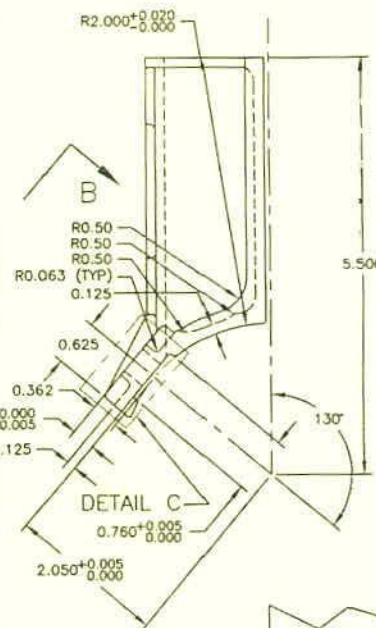
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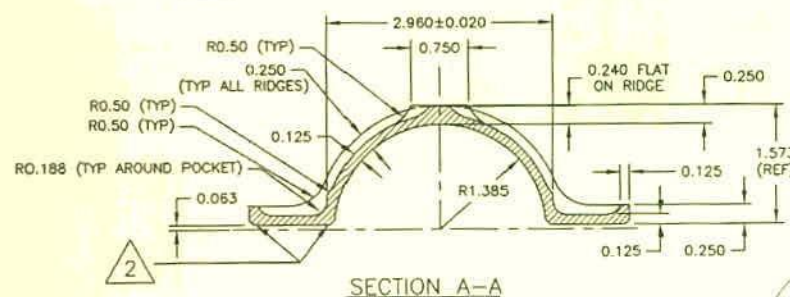
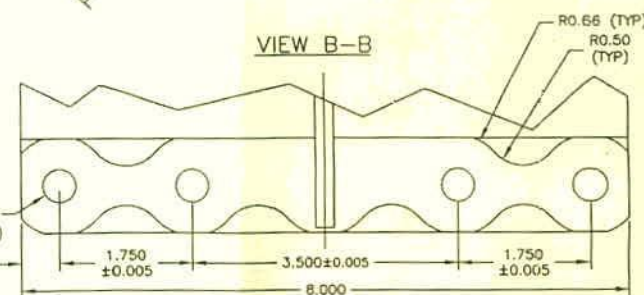
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

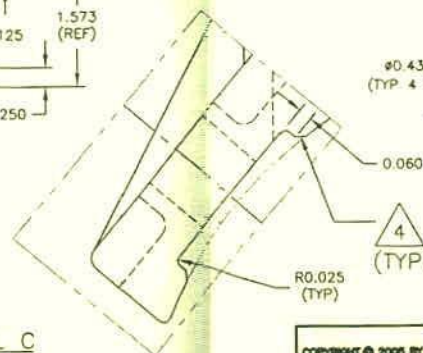
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



VIEW B-B



SECTION A-A

DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED		APPROVED			
DATE	05.07.13	TITLE	INNER FWD SADDLE		

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DART AEROSPACE LTD.

DRAWING NO.
D2572REV. E
SHEET 1 OF 1SCALE
2:3

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